



Dart Aerospace Ltd.
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D3912-1

Job Sheet 195804



Part No: D3912-1

Job Qty: 12 pcs

Part Name: Eyebolt



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 6/7/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP RevA: New issue DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	12 pcs	6/7/19	6/7/19	0.00	8.57	Doosan - 1		JL 19-6-12
110	QC 2	12 pcs	6/7/19	6/7/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		JL
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



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Container No: S189659



Part: D3912-1

Job No: 195804

Serial No/Batch: S189659

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/12/19

				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
120 QC 8	12 pcs	6/7/19	0.00 0.00	QC 8 - 12	On 19/06/13
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Packaging 3-1 - Stock - B4B	12 pcs	6/7/19	0.00 0.00	Packaging 3 - 1 - B4B	STOS 6/13 JUN 14 2019
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	

					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	12 pcs	6/7/19	0.00 0.00	QC 21 - SA - 21	21	
				QC 21 - SA - 70	21	
				QC 21 - SA - 53	21	JUN 17 2019

Part Op **100** - (Doosan Lathe) TURN AS PER FOLIO FA871AND DWG Prog Rev: B Deburr as required
 Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	3.3600 ft (.28 ea)	100-Doosan - 1	563533-68

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R2.000	3	23	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eyebolt	0.130Inches ± 0.030	0.160 0.100	.127	
2	Eyebolt	0.700Inches ± 0.010	0.710 0.690	.7	
3	Eyebolt	0.500Inches ± 0.010	0.510 0.490	.5	
4	Eyebolt	0.900Inches ± 0.030	0.930 0.870	.903	
5	Eyebolt	0.130Inches ± 0.030	0.160 0.100	.135	
6	Eyebolt	45.0Degrees ± 0.5	45.5 44.5	45°	
7	Eyebolt	0.220Inches ± 0.030	0.250 0.190	.219	
8	Eyebolt	0.750Inches ± 0.030	0.780 0.720	.749	
9	Eyebolt	0.970Inches ± 0.010	0.980 0.960	.967	
10	Eyebolt	1.720Inches ± 0.030	1.750 1.690	1.72	
11	Eyebolt	1.200Inches ± 0.030	1.230 1.170	1.2	
12	Eyebolt	0.6250Inches ± 0.0100	0.6350 0.6150	.622	
13	Eyebolt	2.230Inches ± 0.030	2.260 2.200	2.230	
14	Eyebolt	0.130Inches ± 0.030	0.160 0.100	0.127 Radius R1/8	
15	Eyebolt	0.015Inches ± 0.010	0.025 0.005	R1/64 Radius	
16	Eyebolt	0.625Inches ± 0.010	0.635 0.615	.623	
17	Eyebolt	0.650Inches ± 0.010	0.660 0.640	.646	
18	Eyebolt	1.100Inches ± 0.010	1.110 1.090	1.102	
19	Eyebolt	0.440Inches ± 0.030	0.470 0.410	.4395	
20	Eyebolt	0.130Inches ± 0.030	0.160 0.100	Radius R1/8	
21	Eyebolt	1.000Inches ± 0.030	1.030 0.970	1.0015	
22	Eyebolt	0.250Inches ± 0.030	0.280 0.220	.244	
23	Eyebolt	0.880Inches ± 0.030	0.910 0.850	.881	
24	Eyebolt	0.110Inches ± 0.030	0.140 0.080	.111	
25	Eyebolt	0.719Inches + 0.010 - 0.000	0.729 0.719	.724	

Plex 5/30/19 3:03 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					